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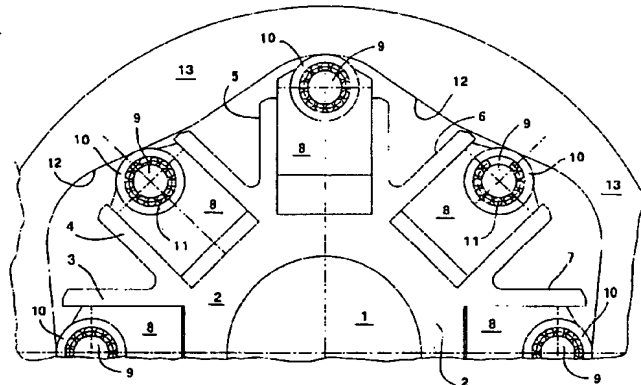
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(54) Title: HIGH EFFICIENCY HYDRAULIC MACHINE WITH RADIAL CYLINDERS



(57) Abstract: The hydraulic machine with radial cylinders (3, 4, 5, 6 and 7) comprises pistons (8) with radial stroke, arranged in contact with an outer cam (13) and coplanar with said group of cylinders, each equipped with a roller on the path (12) of said cam, and it has, in each piston (8), a rolling bearing (9, 10, 11), arranged with the inner ring coupled or coinciding with the pin (9) for supporting said roller (10) and the outer ring (10) coupled or coinciding with the roller (10) itself; moreover, it has the roller (10) and the corresponding rolling bearing (9, 10, 11) with a small size such as to also allow, in the alternating motion of the piston (8), introduction steps of said roller in the respective liner of the cylinder (3, 4, 5, 6 and 7). It comprises, in a further embodiment, in each piston (21), an anti-friction ferrule, (23) placed in contact with the pin (22) or with an interpositioned and coupled support element (25) for said roller (20); said ferrule being coupled with the inner diameter of the roller (20) itself. Finally, in a more complete embodiment, it comprises both the static and dynamic O-rings each consisting of a metal ring (28, 31) mounted with interference in the coupling on the sealing diameter (D) and housed in a throat (29, 36) with slight axial clearance.

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## HIGH EFFICIENCY HYDRAULIC MACHINE WITH RADIAL CYLINDERS

The invention concerns a high efficiency hydraulic machine with radial cylinders, that is a machine in which  
5 said radial cylinders rotate with the drive shaft and through the rolling of a roller associated with the relative piston cross an outer path, or else the path itself rotates, equipped with cams for the generation of alternating motion, in which the composition of the pistons  
10 allows a high efficiency to be attained.

The state of the art comprises the hydraulic machines that have been known for years in which in said cylinders the pistons move behind the action of the outer cam and against which they are thrust by the pressure of the  
15 hydraulic liquid present in them. Said type of machine foresees using a roller arranged inside the piston itself between the outer end of each piston and the cam. The rotation of the shaft, or of the liner with the cam, makes said roller slide on the cam realising the radial  
20 alternating motion of the piston in the corresponding cylinder. Said rollers are coupled with the corresponding piston with a portion of anti-friction ferrule or with a hydrostatic support bearing: from this comes substantial energy consumption, during the compression of the piston  
25 against the path of said cam, indeed by sliding friction between said roller and the piston itself or by leaking of the liquid from said hydraulic bearing. In this last case the hydraulic machine is slightly larger due to the fact that the roller, obviously larger in size, does not enter  
30 into the diameter of the liner.

Versions of this type of hydraulic machine have been realised in which each piston is supported by a pin outside of the cylinder in which the piston is inserted; at the side of this pin two rolling bearings are arranged to  
35 reduce the friction. These rolling bearings have the outer

ring in contact with said cam, in this case double, i.e. on both sides of the group of cylinders and with the greatest diameter of the cylinder group itself. This embodiment, although realising a good energy yield in contact between  
5 pistons and cam, through the contact of said pairs of rolling bearings with the pair of cams, has substantial bulk which prevents it from being used widely and easily.

Such a state of the art is susceptible to substantial improvements with respect to the possibility of realising a  
10 hydraulic machine with radial cylinders which, having a high efficiency, also has low bulk.

From the above derives the need to solve the technical problem of overcoming the teaching of the previous embodiments and realising a support with minimum bulk such  
15 as to be able to be introduced inside the roller on said outer path, to support the substantial specific pressures generated in the thrust.

A further technical problem is that of minimising the spaces occupied by the inactive parts of the motor and, on  
20 the other hand, increasing the spaces occupied by active parts of the motor.

The invention solves the aforementioned technical problem by adopting a hydraulic machine with radial cylinders of the type comprising the pistons with radial  
25 stroke, arranged in contact with an outer cam and coplanar with said group of cylinders, each equipped with a roller on the path of said cam, characterised in that it has, in each piston, a rolling bearing arranged with the inner ring coupled or coinciding with the support pin for said roller  
30 and the outer ring coupled or coinciding with the roller itself.

Moreover, in a further embodiment, by adopting the roller and the corresponding rolling bearing of a small size such as to allow entry into the liner of the cylinder.

35 By adopting, in addition, a piston for a hydraulic

machine with radial cylinders with the pistons with radial stroke, arranged in contact with an outer cam and coplanar with said group of cylinders, equipped with a roller on the path of said cam, characterised in that it has said roller  
5 coupled in rotation with said piston with a rolling bearing.

Furthermore, in a further embodiment, by adopting, in each piston, an anti-friction ferrule placed in contact with the pin or with an interpositioned and coupled support  
10 element for said roller; said ferrule being coupled with the inner diameter of the roller itself.

Moreover, in a further embodiment, by adopting said element placed between the pin and the anti-friction ferrule consisting of a spacer sleeve mounted with  
15 interference on said pin: the anti-friction surface of the ferrule is in sliding contact on the outer surface of said sleeve.

Furthermore, in a further embodiment, by adopting said ferrule in planar iron material wound inside said roller, on which there is a layer of anti-friction plastic material  
20 stably anchored on it through a layer of sintered metal.

Moreover, in a further embodiment, by adopting the thickness of the element in iron material of said bearing between 0.4 and 4% of the sliding diameter; advantageously,  
25 the thrust blocks at the sides of said roller resting upon the shoulders of the piston, equipped with at least one face, a layer of anti-friction plastic material and the sintered anchoring layer thereof.

Furthermore, in a further embodiment, by adopting the thickness of said layer of anti-friction plastic material advantageously between 1 and 12 1/100 of a millimetre and  
30 the thickness of said sintered metal anchoring layer between 10 and 40 1/100 of a millimetre.

By adopting, in addition, a piston for a hydraulic  
35 machine with radial cylinders with the pistons with radial

stroke, arranged in contact with an outer cam and coplanar with said group of cylinders, equipped with a roller on the path of said cam, characterised in that it has said roller coupled in rotation with said piston with an anti-friction  
5 ferrule and relative support pin.

Finally, by adopting, in the seals of the hydraulic machines with radial cylinders, both static and dynamic O-rings each consisting of a metal ring mounted with interference in the coupling on the sealing diameter and  
10 housed in a throat with slight axial clearance; advantageously, they have a large depth of said throat with respect to its width and the width of the ring and the side shoulder of each O-ring with a width a little greater than the depth of the throat.

15 An embodiment of the invention is illustrated as an example in the attached six tables of drawings in which Figure 1 is the side schematic view of a hydraulic machine according to the present invention; Figure 2 is the schematic view of a partial radial section of the single  
20 radial cylinder; Figure 3 is a schematic view in section III-III of figure 2; Figure 4 is a schematic side view of a piston complete with roller and pin for rotation of a second embodiment of the present invention; Figure 5 is a schematic side section view of the piston of the previous  
25 figure; Figure 6 is a schematic side view of the piston of figures 4 and 5; Figure 7 is a schematic axial section view of the piston of figure 4; Figure 8 is a schematic diametric section view of the piston of figure 4; Figure 9 is a schematic axial view of a motor with an outer cam and  
30 radial cylinders, equipped with a displacement selector, in which metal O-rings are applied in a further aspect of the present invention; Figure 10 is a schematic axial section view of the piston, like figure 7, but with a different way of lubricating the sliding contact between roller and pin.

35 Figures 1 shows the drive shaft 1, rigidly connected to

and rotating with the cylinder group 2 in which, in the cylinders shown 3, 4, 5, 6 and 7, there are pistons 8 equipped with a pin 9 on which the outer ring 10 is coupled in rotation through the interposition of small rollers 11, constituting a rolling bearing with rollers. The outer ring 10 is therefore made to roll on the path 12 of the cam 13, arranged in the same axial plane as the cylinder group 2; said ring constitutes the roller of the piston on said path.

Moreover, figure 2 shows the rolling bearing 14 for supporting the drive shaft 1 in rotation on the liner 15 of the hydraulic machine. Said pin 9 is rigidly connected to the body of the piston 8 through caulking 16 of its ends. The small rollers 11 are spaced apart, advantageously, through a single central cage 17, arranged in the middle of them with a seat formed in the outer ring 10 which, as stated, acts as a roller of the piston 8 on said path 12. Said pistons 8 are kept in position by the abutment clip 18 sliding in the axial stubbling 19 on the side of said piston.

Furthermore, figures 4 to 8 show a further embodiment, for obtaining the high efficiency hydraulic machine, comprising a rotating support between the roller 20 and the piston 21 in which the rotation support pin 22, of said roller 20 through the ferrule 23, realised through a planar element 24 in iron material, is wound inside said roller 20, on which there is a layer of anti-friction plastic material stably anchored on it through a layer of sintered metal; said ferrule being with the inner surface in contact and sliding on the outer surface of a spacer sleeve 25 coupled with said pin 22, with substantial interference. The shoulders 26 of piston 21 support the extremities of said pin 22 with interference, whereas said spacer sleeve 25 realises the axial shouldering of said shoulders 26 during assembly. Moreover, in the axial contact between

said shoulders 26 and the roller 20, the thrust blocks 27 are inserted, consisting of the metal body and coating on one face with said layer of anti-friction plastic material and said sintered anchoring layer. Finally, said figures  
5 show the metal O-ring 28 coupled with interference at the diameter of the liner of the cylinder and inserted in a seat 29, in the piston 21, with slight side clearance; the low thickness and the elasticity in elongation allow the assembly of the entire ring 28 in said seat 29.

10 Figure 9 shows a further embodiment, for obtaining the high efficiency hydraulic machine, in which the sizing of the distributor 30, thanks to the application of the static and/or rotating seals 31 with the metal ring 32, allows the passage sections 33 for the hydraulic liquid to be  
15 substantially increased without, moreover, increasing the bulk of the hydraulic machine. This result is obtained since said seals allow the size of the parts adjacent to them, such as the side shoulders 34 of the seats of the metal O-rings 32, to be greatly decreased. Indeed, said  
20 figure 9 shows a motor with the selection of the active cylinders for the partialisation 35 of the displacement, as in the prior art, which however involves the construction of a distributor that is bulkier than usual. By adopting, on the other hand, said static and/or rotating seals 31,  
25 consisting of said metal ring mounted with interference on the sealing diameter D and with slight clearance in the seat 36, formed in the coupling hole of said diameter D. The seat 36 is sized with depth of the throat equal to at least 1.5 times the width B of said metal ring 35 in order  
30 to allow the assembly of the entire ring inside the hole. .

In figure 10, finally, the pin 37 is equipped with a communication hole 38 of the pressurised hydraulic fluid from the crown of the piston 39, which with said hole 38, the duct 40 of the piston and the hole 41 of the sleeve  
35 takes said fluid in the sliding surface between said sleeve

and the ferrule 23.

The operation of the hydraulic machine according to figures 1-3 has a substantial reduction in friction between the pin 8 and the roller in this case represented by the outer ring 10 of the rolling bearing formed in the end of the piston.

Consequently, the efficiency of the hydraulic machine with radial pistons, of the type described here, has an improvement from the usual 70% to 90% on average near to the static torque. A substantial economic advantage can be obtained by replacing the previous pistons with the roller with sliding friction with the new pistons equipped with the rolling bearing described here. Said hydraulic machine shall thus have a somewhat higher efficiency decreasing the energy wastage to obtain the same work without the need to integrally replace the machine itself.

The pin 9 and the outer ring 10 are treated with setting heat treatments, advantageously carried out on steel of the type with minimised inclusions, to allow a sufficient lifetime of the rolling surfaces.

The performance of the pistons 21 according to figures 4-8, equipped with the rotation support of the roller 20 allows an excellent reduction in sliding friction to be realised with the sliding of the inner surface made from anti-friction plastic material of the ferrule 23 since the thickness of the layer of anti-friction plastic material is minimal, but slightly greater than the maximum size of the particles not held by the filter of the hydraulic circuit where the hydraulic machine is inserted; it also has the thickness of the element in iron material of said bearing between 0.4 and 4% of the sliding diameter on said spacer sleeve 25. In this way, the heat generated in sliding is easily transmitted from the plastic material to the metal parts of the piston without taking said plastic material to critical conditions. In the same way, the thrust blocks 27,



precisely because they are equipped with at least one face with said layer of anti-friction plastic material and said sintered anchoring layer, substantially reduce the friction in the side thrusts which the roller 20 causes on the shoulders 26 of the piston 21 in its alternating radial motion following the cam 13.

Thus, advantageously, the thickness of the interpositioned thrust blocks 27 in iron material between 10 and 16  $\frac{1}{10}$  of a millimetre excluding the thickness of the anti-friction plastic material and anchoring sintered layers. Moreover, both in the case of the ferrule and for said thrust block, the thickness of said layer of anti-friction plastic material is advantageously between 1 and 12  $\frac{1}{100}$  of a millimetre; and the thickness of said layer of anchoring sintered metal is between 10 and 40  $\frac{1}{100}$  of a millimetre.

Finally, in the new embodiment of the hydraulic machine with the distributor 30 according to figure 9, the shoulders 34 can be reduced to a size slightly greater than the depth of the throat 36. The size of said ring 32 also allows the dimension C of the shoulder 34 to be taken to 2 mm: the width B of the metal O-ring 32 is 1 mm and the depth of the throat 36 is slightly more than 1.5 mm. These seals with a metal ring 32 have given excellent results both if arranged on mutually static surfaces, like indeed between the distributor 30 and its coupling seats, and in the position where the mutual rotation between shaft and seat is strong, like in the coupling between the shaft 1 and its support in the crankcase of the hydraulic machine.

The advantages obtained with the present invention are: the drastic improvement of the losses for friction in the rolling of the roller on the path and on the piston; indeed, the separation of the roller/path and roller/pin sliding surfaces allows the mounting up of the effects of sliding of the outer surface of the roller on the piston

and of rolling on the surface of the cam, typical of the state of the art, to be avoided. Thus, according to the present invention between the outer surface of the roller and the cam, there is just rolling friction, whereas between  
5 the roller and the support pin there can be sliding friction, with the sliding bearing, or sliding friction, with the aforementioned anti-friction ferrule.

In practical embodiment the materials, the sizes and the embodying details can be different from those indicated,  
10 but technically equivalent to them, without for this reason departing from the legal protection of the present invention.

## CLAIMS

1) Hydraulic machine with radial cylinders (3, 4, 5, 6 and 7) of the type comprising pistons (8) with radial stroke, arranged in contact with an outer cam (13) and coplanar with said group of cylinders, each equipped with a roller on the path (12) of said cam, characterised in that it has, in each piston (8), a rolling bearing (9, 10, 11), arranged with the inner ring coupled or coinciding with the pin (9) for supporting said roller (10) and the outer ring (10) coupled or coinciding with the roller (10) itself.

2) Hydraulic machine according to the previous claim, characterised in that it has the roller (10) and the corresponding rolling bearing (9, 10, 11) with a small size such as to also allow, in the alternating motion of the piston (8), introduction steps of said roller in the liner of the cylinder (3, 4, 5, 6 and 7).

3) Hydraulic machine according to one of the previous claims 1 and 2, characterised in that it has said bearing (9, 10, 11) of the so-called full filling type.

4) Hydraulic machine according to one of the previous claims 1 and 2, characterised in that it has said rolling bearing with rollers (11) with an annular cage.

5) Hydraulic machine according to the previous claims 4, characterised in that it has said bearing (9, 10, 11) with the annular cage (17) in the middle of the bearing.

6) Hydraulic machine according to one of the previous claims, characterised in that it has said bearing (9, 10, 11) with the pin (9) and the outer ring (10) treated with setting heat treatments on steel of the type with minimised inclusions.

7) Piston for a hydraulic machine with radial cylinders with the pistons (8) with radial stroke, arranged in contact with an outer cam (13) and coplanar with said group of cylinders, equipped with a roller on the path (12) of said cam, characterised in that it has said roller (10)

coupled in rotation with said piston with a rolling bearing (9, 10, 11) according to one or more of the previous claims 1 to 6.

8) Hydraulic machine with radial cylinders (3, 4, 5, 6 and 7) of the type comprising pistons (21) with radial stroke, arranged in contact with an outer cam (13) and coplanar with said group of cylinders, each equipped with a roller on the path (12) of said cam, characterised in that it has, in each piston (21), an anti-friction ferrule (23) placed in contact with the pin (22) or with an interpositioned and coupled support element (25) for said roller (20); said ferrule being coupled with the inner diameter of the roller (20) itself.

9) Hydraulic machine according to the previous claim 8, characterised in that it has said element positioned between the pin (22) and the anti-friction ferrule (23) consisting of a spacer sleeve (25) mounted with interference on said pin (22); the anti-friction surface of the ferrule (23) is in sliding contact on the outer surface of said sleeve.

10) Hydraulic machine according to the previous claims 8 and 9, characterised in that it has said ferrule in planar iron material, wound inside said roller (20), on which there is a layer of anti-friction plastic material anchored in a stable way on it through a layer of sintered metal.

11) Hydraulic machine according to the previous claim 10, characterised in that it has the thickness of the element in iron material of said bearing between 0.4 and 4% of the sliding diameter.

12) Hydraulic machine according to one of the previous claims 8 to 11, characterised in that it has thrust blocks (27) at the sides of said roller (20) resting upon the shoulders (26) of the piston (21), equipped with at least one face, a layer of anti-friction plastic

material and the sintered anchoring layer thereof.

13) Hydraulic machine according to one of the previous claims 8, 9, 10 or 12, characterised in that it has the thickness of said layer of anti-friction plastic material advantageously between 1 and 12 1/100 of a millimetre and the thickness of said sintered metal anchoring layer between 10 and 40 1/100 of a millimetre.

14) Piston for a hydraulic machine with radial cylinders with the pistons (21) with radial stroke, arranged in contact with an outer cam (13) and coplanar with said group of cylinders, equipped with a roller on the path (20) of said cam, characterised in that it has said roller (20) coupled in rotation with said piston with an anti-friction ferrule and relative support pin (22) according to one or more of the previous claims 8 to 13.

15) Hydraulic machine with radial cylinders (3, 4, 5, 6 and 7) of the type comprising pistons (8, 21) with radial stroke, arranged in contact with an outer cam (13) and coplanar with said group of cylinders, each equipped with a roller on the path (12, 20) of said cam, characterised in that it has both the static and dynamic O-rings (28, 31) each consisting of a metal ring (28, 32) mounted with interference in the coupling on the sealing diameter (D) and housed in a throat (29, 36) with slight axial clearance.

16) Hydraulic machine according to the previous claim 15, characterised in that it has a large depth of said throat (36) with respect to its width (B) and that of the ring (32).

17) Hydraulic machine according to the previous claim 16, characterised in that it has the side shoulder (34) of each O-ring (31) with a width (C) slightly greater than the depth of the throat (36).

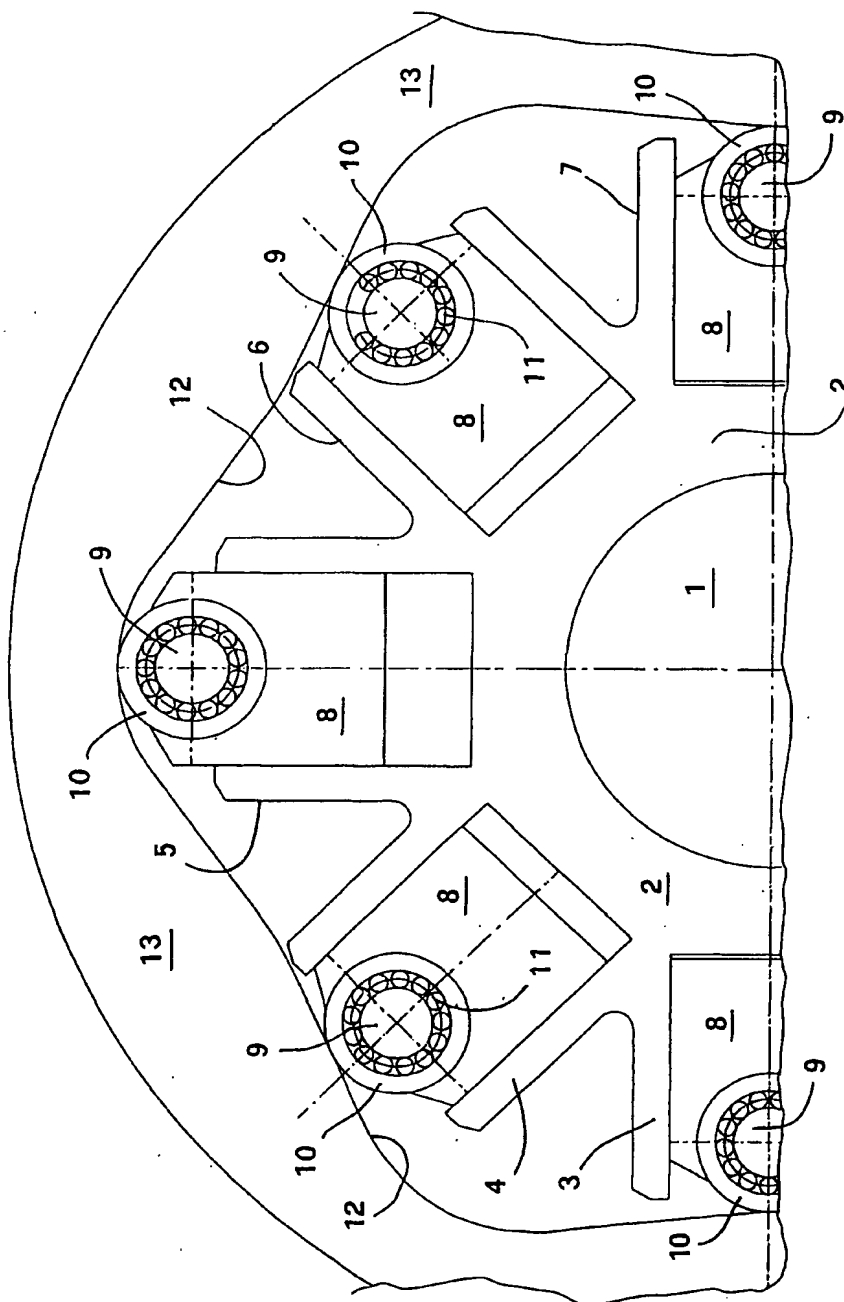
18) Hydraulic machine according to one of the previous claims 15 to 17, characterised in that it has the

roller (10) supported by the pin (9) with a rolling friction bearing, according to one of the previous claims 1 to 6.

19) Hydraulic machine according to one of the previous claims 15 to 17, characterised in that it has the roller (21) supported by the pin (22) with a sliding friction bearing with an anti-friction ferrule (23), according to one of the previous claims 8 to 13.

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Fig.1



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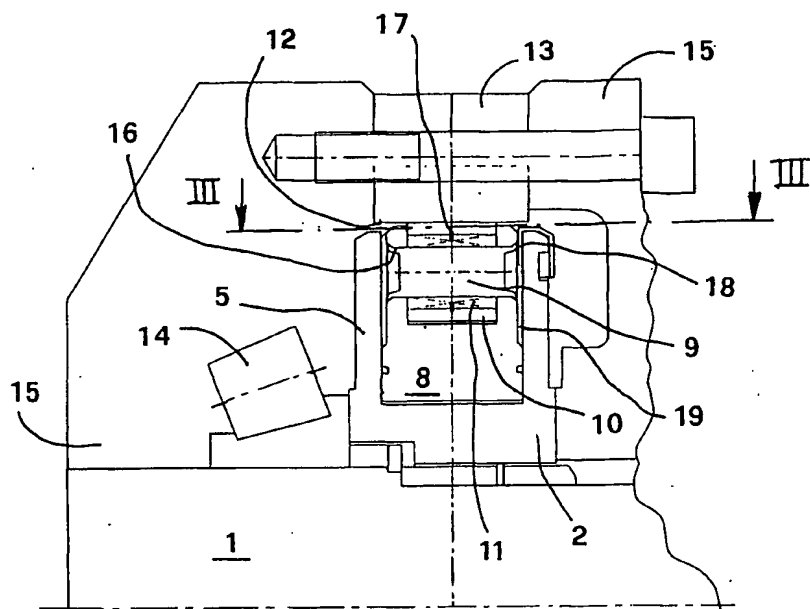


Fig. 2

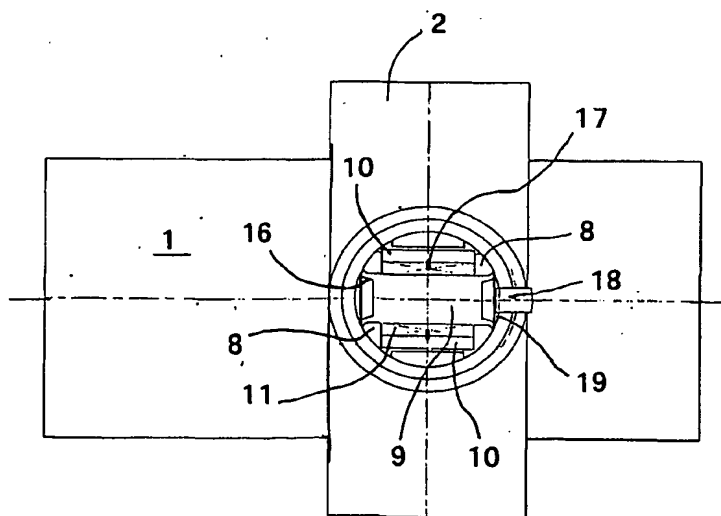


Fig. 3



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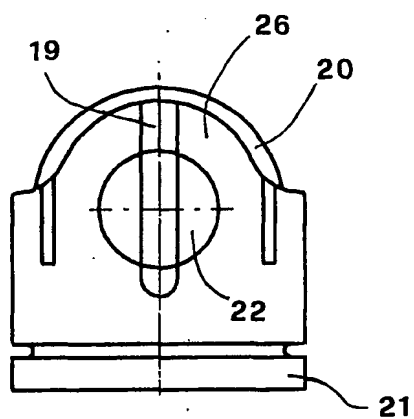


Fig. 4

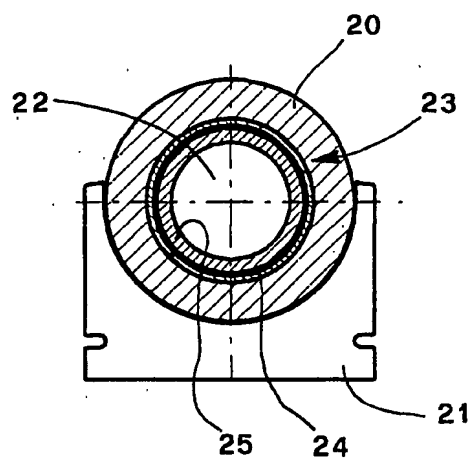


Fig. 5

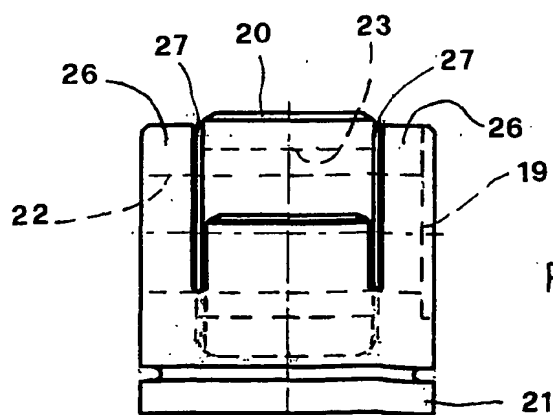


Fig. 6

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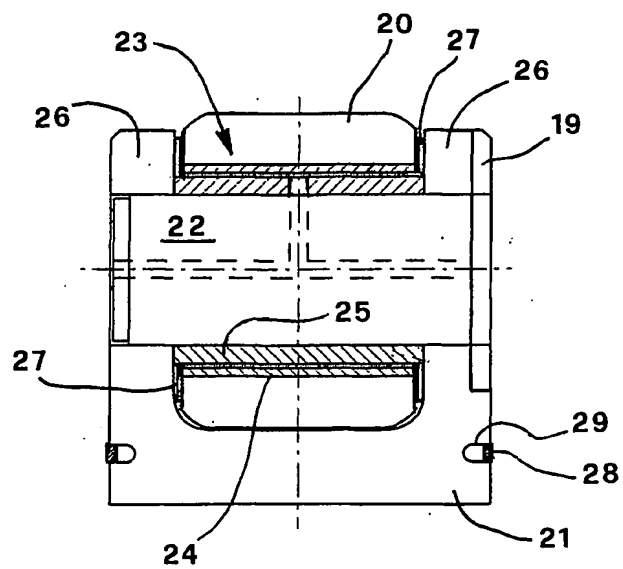


Fig. 7

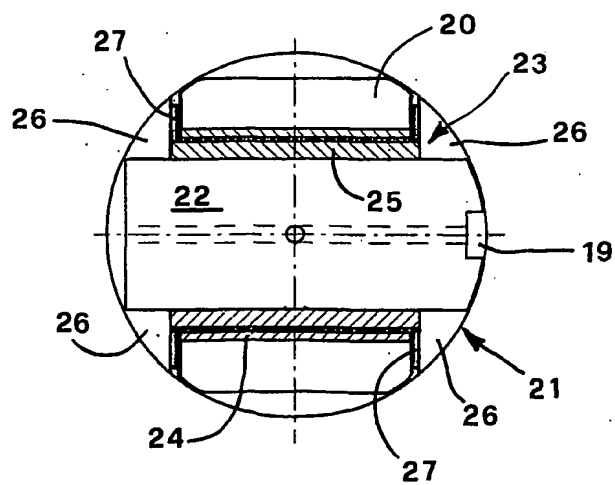


Fig. 8

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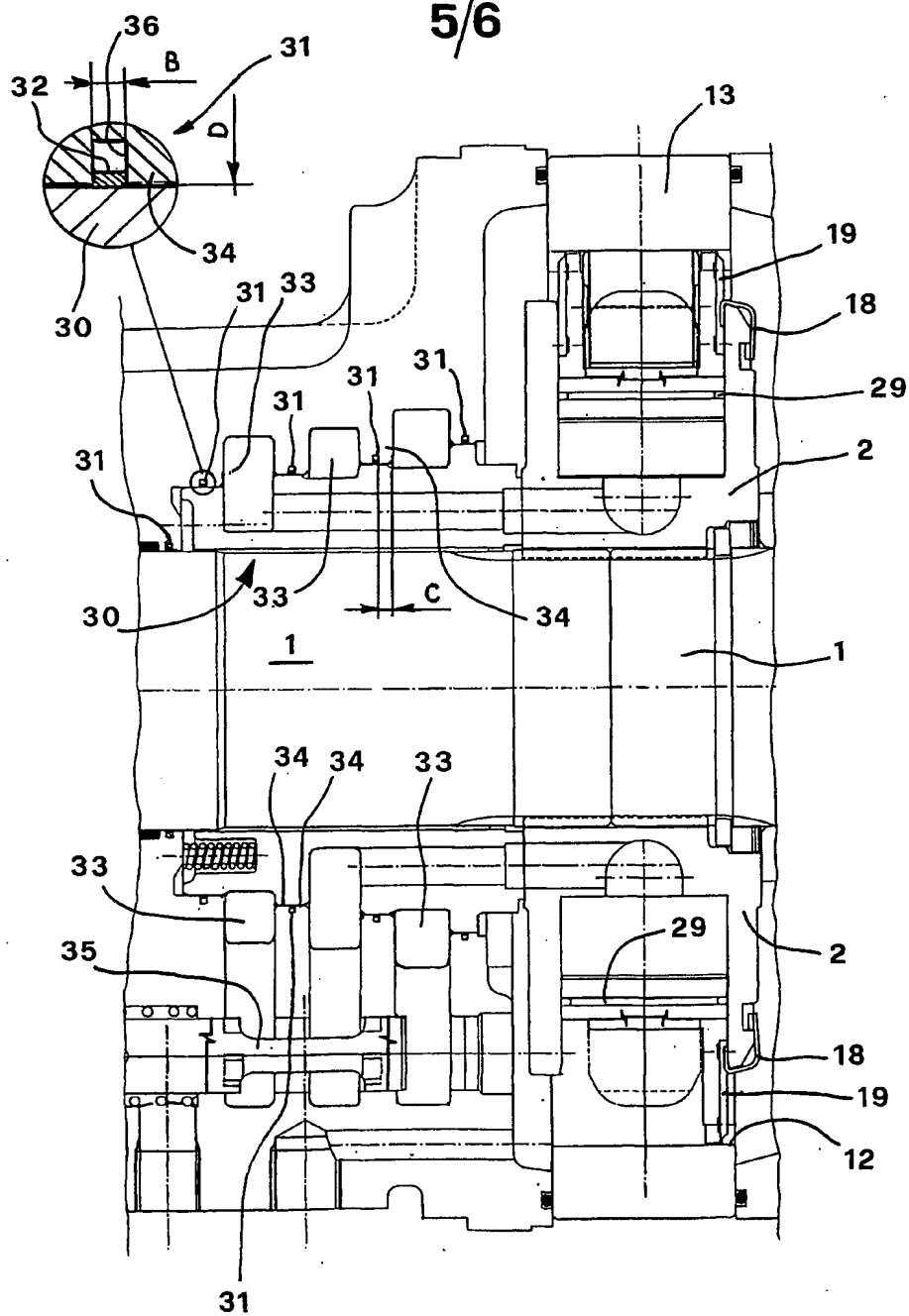


Fig. 9

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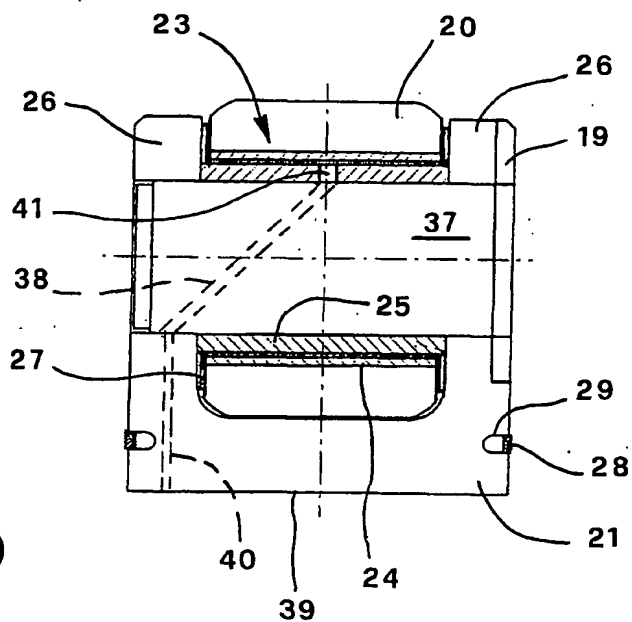


Fig. 10

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## INTERNATIONAL SEARCH REPORT

International Application No  
PCT/IT 03/00593A. CLASSIFICATION OF SUBJECT MATTER  
IPC 7 F03C1/24

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)  
IPC 7 F03C F04B F01B F16C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the International search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	CH 244 148 A (BLANC EUGENE) 31 August 1946 (1946-08-31)	1,2,7
Y	page 1, line 24 - page 2, line 15; claim 3; figures 1,2	4-6
X	US 3 357 312 A (JAKOVLEVICH ROGOV ANATOLY ET AL) 12 December 1967 (1967-12-12) column 7, line 51 - column 7, line 61; figures 1,5	1,7
X	GB 441 760 A (CHARLES HYLAND) 24 January 1936 (1936-01-24) page 1, line 67 - page 1, line 85; figure 1	1,7
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☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

## \* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

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Date of the actual completion of the international search

23 March 2004

Date of mailing of the international search report

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Name and mailing address of the ISA

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# INTERNATIONAL SEARCH REPORT

International Application No

PCT/IT 03/00593

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 3 994 544 A (FLATLAND LLOYD P) 30 November 1976 (1976-11-30) column 2, line 12 - column 2, line 34; figure 1 -----	4,5
Y	US 3 477 884 A (SCHLICHT HANS GEORG) 11 November 1969 (1969-11-11) abstract column 2, line 21 - column 2, line 34 -----	6

# INTERNATIONAL SEARCH REPORT

International application No.  
PCT/IT 03/00593

## Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:  
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☒ Claims Nos.: 3  
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:  
see FURTHER INFORMATION sheet PCT/ISA/210
3. ☐ Claims Nos.:  
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

## Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☐ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☒ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:  
1,2,4-7

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☐ No protest accompanied the payment of additional search fees.

Continuation of Box I.2

Claims Nos.: 3

The wording "full filling type" in present claim 3 is unclear. Hence, claim 3 lacks clarity within the meaning of Article 6 PCT to such an extent as to render a meaningful search of this claim impossible.

The applicant's attention is drawn to the fact that claims relating to inventions in respect of which no international search report has been established need not be the subject of an international preliminary examination (Rule 66.1(e) PCT). The applicant is advised that the EPO policy when acting as an International Preliminary Examining Authority is normally not to carry out a preliminary examination on matter which has not been searched. This is the case irrespective of whether or not the claims are amended following receipt of the search report or during any Chapter II procedure. If the application proceeds into the regional phase before the EPO, the applicant is reminded that a search may be carried out during examination before the EPO (see EPO Guideline C-VI, 8.5), should the problems which led to the Article 17(2) declaration be overcome.



This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1,2,4-7

Hydraulic machine with radial cylinders with rollers mounted on a rolling bearing.  
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2. claims: 8-14

Hydraulic machine with radial cylinders with rollers mounted on a sliding bearing.  
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3. claims: 15-19

Hydraulic machine with radial cylinders with O-rings consisting of a metal ring.  
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# INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/IT 03/00593

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
CH 244148	A	31-08-1946	NONE
US 3357312	A	12-12-1967	NONE
GB 441760	A	24-01-1936	NONE
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